

July 6

Dart Aerospace Ltd.

Date: Tuesday, 6/26/2007 3:06:34 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SMALL ENGINE MOUNT  
 Job Number : 33131  
 Estimate Number : 12611  
 P.O. Number : NIA Part Number : D2127251110  
 This Issue : 6/26/2007 S.O. No. : NIA Drawing Number : D212-725-1 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : KB  
 Previous Run : 30060 Material : NIA Due Date : 7/3/2007 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By : 07.06.27  
 Comment : Est Rev. New Issue 06-12-19 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4140NB1500X15000 AISI 4140 Steel Bar



Comment: Qty.: 0.2972 f(s)/Unit Total : 1.1886 f(s)

AISI 4140 Steel Bar 1.500" X 1.500"

Batch: 104993

BF 07.07.16 (5)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 3.400" long

BF 07.07.17 (5)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA657 and Dwg D212-725-1

BF 07.07.17 (5)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BF 07.07.17 (5)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

IL 07/07/17 (5)

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

7/0: 4193 C207107117 (5)  
 EP 07/07/25 (5)

5.1 PG CAP Plate as per Dwg D212-725-1

5.2 PK RECEIVE: Inspect for Damage - see 6/27

5.3 QCB → in 07/07/26 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 01/01/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:06:34 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SMALL ENGINE MOUNT

Job Number: 33131

Part Number: D2127251110

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

*Done 7/27*

Job Completion



*u of 27*

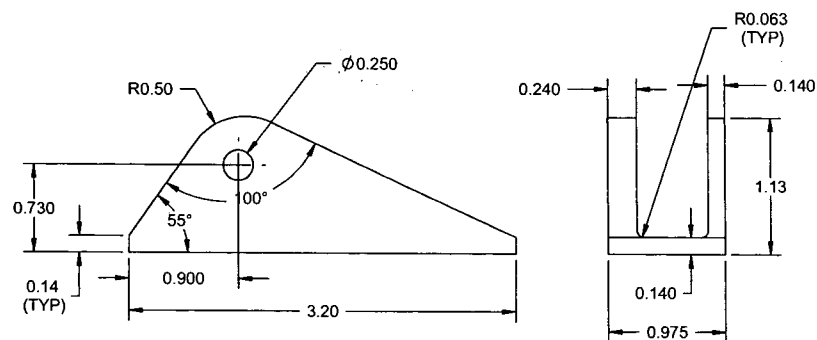
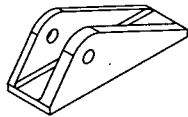
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

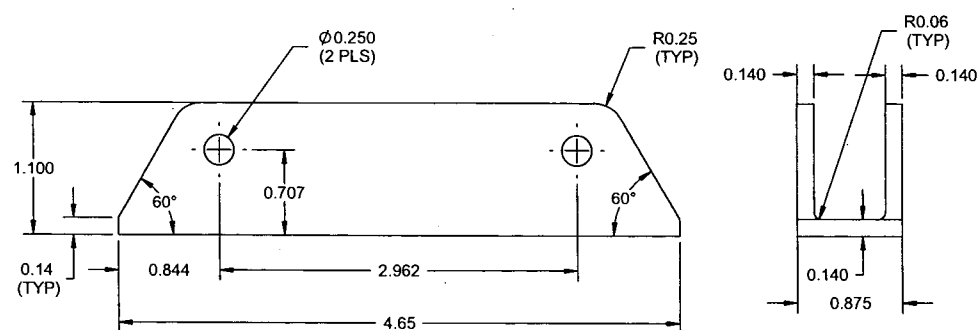
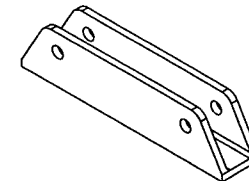
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D212-725-1-109 SMALL ENGINE MOUNT**  
**D212-725-1-110 OPPOSITE**



**D212-725-1-111 LARGE ENGINE MOUNT**

NO. 33131  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

**D212-725-1-109/110/111 NOTES:**

- 1) MATERIAL: AISI 4140/4130 STEEL BAR PER MIL-S-5626/-6758 OR AMS 6382/6349/6529 OR AMS 6348/6370/6528 (REF. DART SPEC. M4140N-B OR M4130N-B) HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
- 2) FINISH: PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN JL	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A SHEET 35 OF 37
DATE 06.12.08		TITLE 212S DETAIL PARTS	SCALE 1:1
COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

<b>DART. AEROSPACE LTD</b>	<b>Work Order:</b>	33131
<b>Description:</b> Small Engine Mount	<b>Part Number:</b>	212-725-1-110
<b>Inspection Dwg:</b> 212-725-1-1009 <b>Rev:</b> A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## First Article

## Prototype

Measured by: <i>BF</i>	Audited by: <i>IL</i>	Prototype Approval:
Date: <i>07-07-17</i>	Date: <i>07/07/17</i>	Date: <i>NA</i>

**MANCO****DOMPLEX**

8895 Crescent 3

Anjou (Québec) H1J 1B6

Tél.: 514-355-7867

Fax: 514-355-8750

**CERTIFICAT DE CONFORMITÉ**  
**CERTIFICATE OF COMPLIANCE**

#1703

Client / Customer DART Aerospace LTDVotre # de commande / Your purchase order #  
PO4193# de la pièce / part #  
1 lot of piecesNotre # de bon de livraison / Our packing slip #  
105061

Inspecteur / Inspector <u>Renner</u>		Date, équipe / Date, shift <u>22/07/07</u>	
Placage / Plating <u>ARP-416 CLASS 1 TYPE II</u>			
Quantité totale / Total quantity <u>1 lot</u>		Quantité inspectée / Inspected quantity <u>1 lot</u>	
Adhésion / Adhesion <u>Good</u>			
Épaisseur / Thickness L.C.D.		Moy. / aver. <u>0.0005</u>	
Couillises, taches / Leach, spots <u>NO</u>		Rugosité / Roughness <u>NO</u>	
Quantité approuvée / Approved quantity <u>1 lot</u>		Quantité rejetée / Rejected quantity	
Commentaires / Comments			

D 7127251110 B3313 = 5 PcsD 1327251111 B331 = 5 Pcs

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de  
Signed on behalf of**MANCO**  
**DOMPLEX**



Placage  
**Manco Domplex**  
Electroplating

Siege social / Head Office Plan 1  
4660 Hickmore 4670 Hickmore  
Ville St-Laurent, Québec Ville St-Laurent, Québec  
H4T 1K2 Fax: (514) 355-5991  
Fax: (514) 355-8750

Plan 2  
8001 Larrey  
Anjou, Québec  
Fax: (514) 354-2937

**BON DE LIVRAISON  
PACKING SLIP**

Tél.: (514) 355-7867 / 1-877-355-7867

V  
S  
E  
N  
D  
D  
U  
T  
A  
O

E  
X  
S  
H  
I  
P  
P  
E  
D  
I  
E  
O  
A

*DMH Aerospace LTD*  
*1270 Aberdeen ST*  
*HAVERBURY ONTARIO*  
*K6A 1K7*

DATE DE COMMANDE ORDER DATE		DATE D'EXPÉDITION DATE SHIPPED		NO. DE COMMANDE P.O. NO.	
VIA <i>URULATOR</i>		PRÉPARÉ PAR PREPARED BY <i>Robert</i>		POUR INFO CONTACTER <i>Robert</i>	
N° DE COM P.O. NO.	DESCRIPTION	SPECIFICATIONS	QUANTITÉ QUANTITY	UN	RÉSERVE RESERVED
<i>P04193</i>	<i>D2132251110 B3313</i>	<i>Yellow</i>	<i>(5)</i>		
<i>P04193</i>	<i>D2132725111 B331</i>	<i>Cadmium</i>	<i>5</i>		
<i>P04039</i>	<i>D2968-041 B33099</i>	<i>Yellow</i>	<i>20</i>		
<i>P04039</i>	<i>D2968-043 B332503</i>	<i>Cadmium</i>	<i>30</i>		
<i>9/30/07/25</i>					
POIDS TOTAL TOTAL WEIGHT		RECU PAR RECEIVED BY			
SIGNATURE		TOTAL DE COLIS TOTAL PARCELS			

AUCUNE RÉCLAMATION APRÈS 5 JOURS DE LA DATE DE LIVRAISON  
NO CLAIMS AFTER 5 DAYS FROM DATE OF DELIVERY

# BON DE LIVRAISON  
*105061*